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(52) UK CL (Edition Q)

E1J JGN

(56) Documents Cited

US 5240664 A US 4979333 A US 4964620 A
US 4960375 A

(58) Field of Search

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Online: World Patents Index, EPODOC, Patent
Abstracts of Japan databases

(54) Abstract Title

A weather strip comprising an extruded portion of varying cross-section and a moulded section

(57) A weather strip 11 for a vehicle door comprises an extruded section 14, with a base 15 and a hollow sealing section 17, and a moulded segment 13 fixed to the rear, upper corner of a door frame connecting the ends of the extruded strip 14. The extrusion process may use a variable cross-section die to alter the cross-section of the strip along its length. Features thus included along selected portions of the strip are a sealing lip 19 along the length of the strip corresponding to the upper section of the door frame, a sealing section of enhanced height at a corner to compensate for deformation of the hollow sealing portion, changes in shape of the hollow seal portion 17 and a reduced wall thickness around the lower door section.

FIG. 1

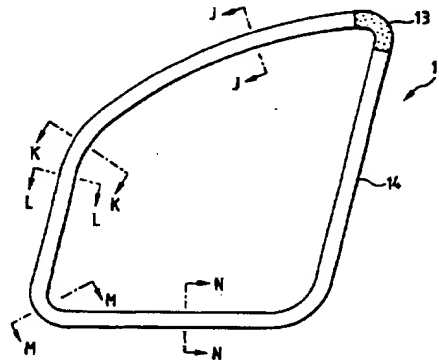
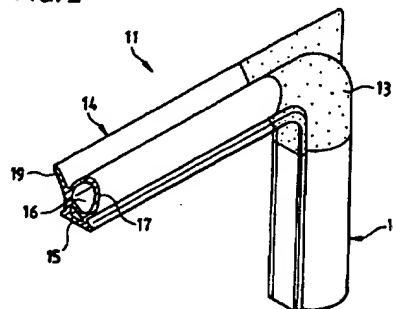


FIG. 2



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FIG. 1

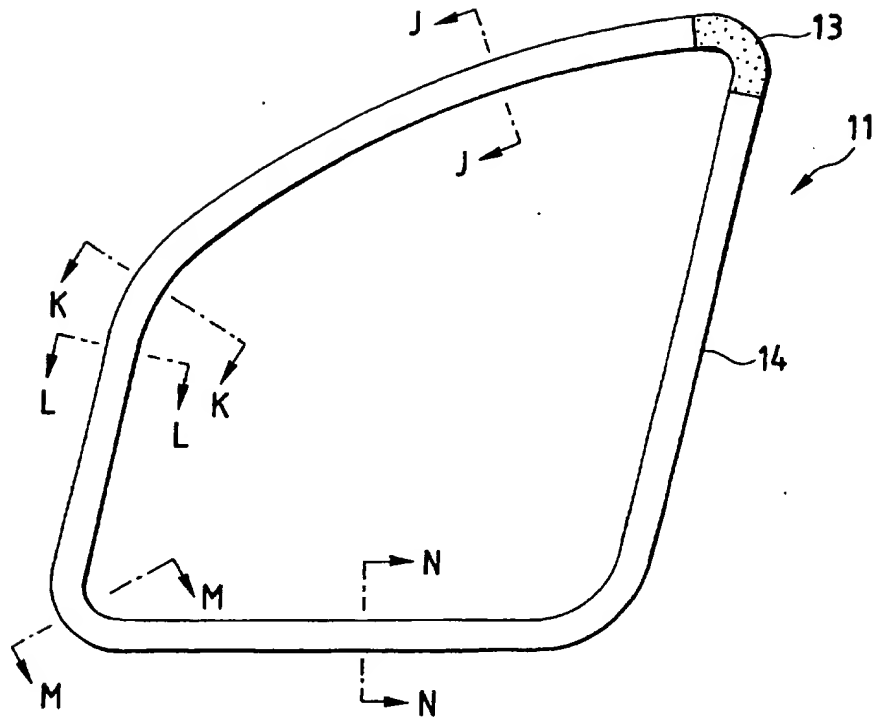


FIG. 2

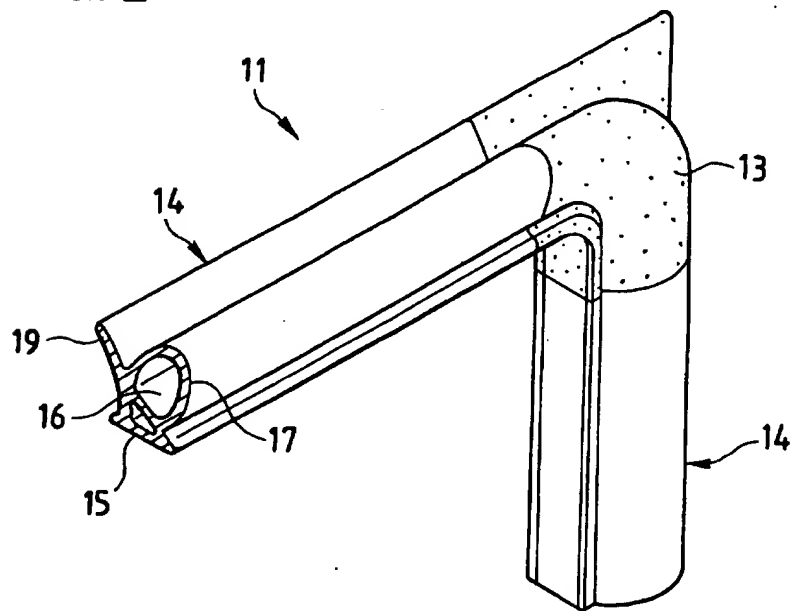


FIG. 3

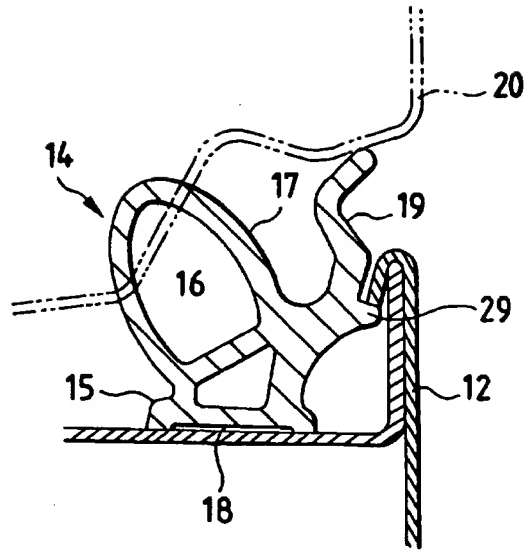


FIG. 4

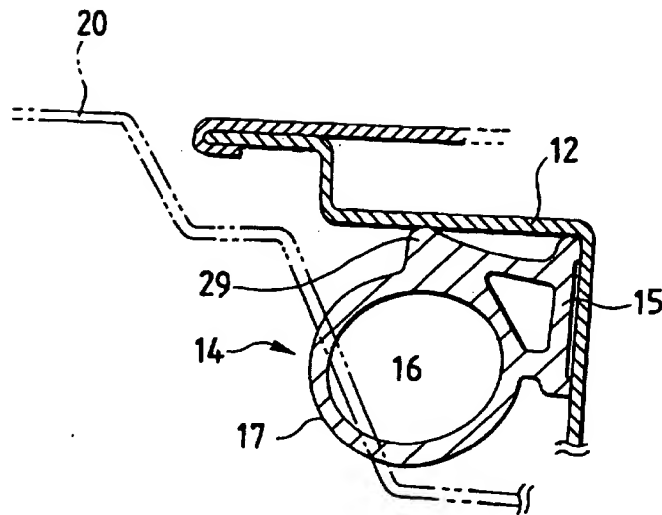


FIG. 5

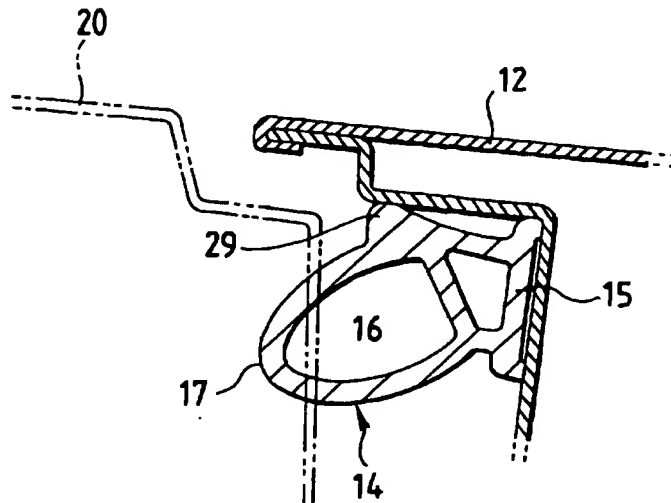


FIG. 6

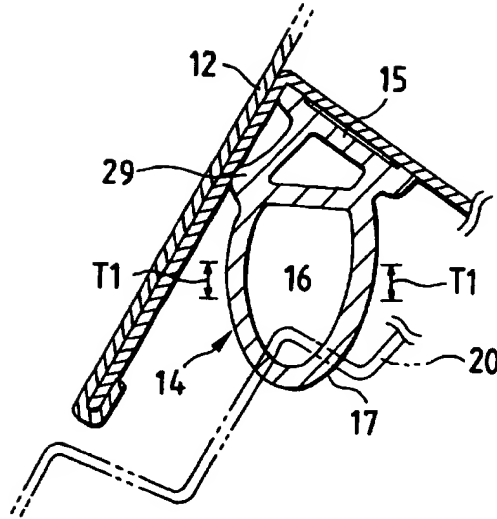


FIG. 7

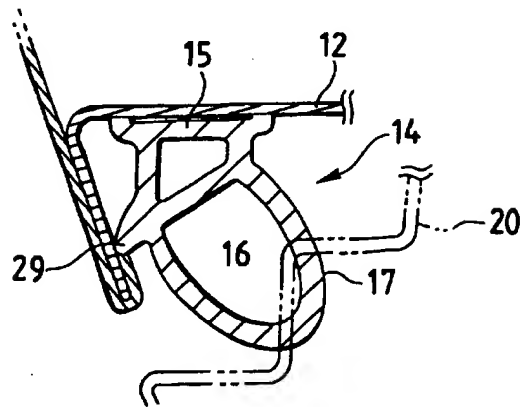


FIG. 8

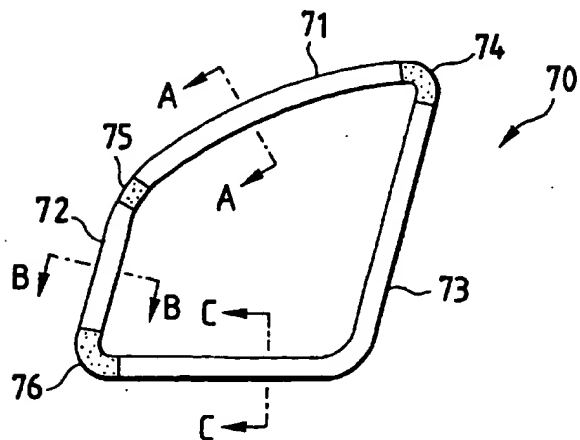


FIG. 9

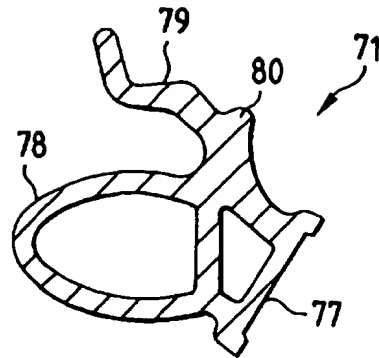


FIG. 10

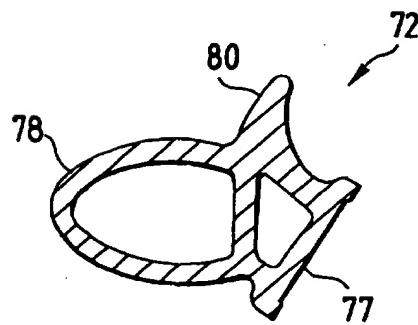
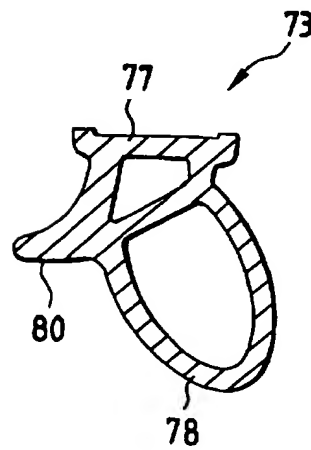


FIG. 11



FRONT DOOR WEATHER STRIP AND MANUFACTURING METHOD THEREFOR

BACKGROUND OF THE INVENTION1. Field of the Invention

5 This invention relates to front door weather strips, and more particularly to a front door weather strip which comprises a base section which is mounted on the periphery of a front door of a vehicle, and a hollow sealing section which is extended from the base section. The front door weather strip is annular as a whole.

2. Description of the Related Art

Heretofore, a front door weather strip is mounted on the periphery of a front door of a vehicle to seal the gap between the front door and the vehicle body. In the weather strip of this type, its mainly substantially straight part is formed by extrusion molding, and its corner part small in the radius of curvature is formed by using a mold (hereinafter referred to as "mold molding", when applicable) (cf. Japanese Utility Model Publication No. Hei. 1-168346, Japanese Utility Model Publication No. Hei. 2-26934, or the like). The weather strip fundamentally comprises a base section which is mounted on the periphery of a front door, and a hollow sealing section which is extended from the base section, and is formed, for instance, with EPDM solid rubber or sponge rubber.

25 FIG. 8 is a side view of a conventional front door weather

strip. As shown in FIG. 8, the weather strip 70 comprises three extrusion molding sections (a first extrusion molding section 71, a second extrusion molding section 72, and a third extrusion molding section 73); and three mold molding sections (a first mold molding section 74, a second mold molding section 75, and a third mold molding section 76) which connect the ends of those three extrusion molding sections and are dotted in FIG. 8. The reason why the mold molding sections 74 through 76 are provided is as follows: If the whole weather strip is formed by extrusion molding suffers from the following trouble: In the case where the corner is small in the radius of curvature, and it is desired to curve the extrusion molding section along the corner section, the corner section is deformed in such a manner that the hollow sealing section collapses; that is, a predetermined sealing force cannot be obtained. The extrusion molding sections are greatly different in sectional configuration from each other, the mold molding section is provided at the junction of the extrusion molding sections.

FIG. 9 is a sectional view taken along line A-A in FIG. 8. FIG 10 is a sectional view taken along line B-B in FIG. 8.

FIG. 11 is a sectional view taken along line C-C in FIG. 8. As shown in those figures, the first extrusion molding section 71 corresponding to the region of from the upper section to the front side section of the front door, as was described before, fundamentally comprises a base section 77, and a hollow sealing

section 78 which is integral with an outwardly protruded seal lip 79, and a rear surface seal 80. On the other hand, the second extrusion molding section 72 corresponding to the front side section of the front door has no seal lip 79. And in the second
5 mold molding section 75, the seal lip 79 is gradually changed in length, and the seal lip 79 is eliminated at the junction of the second extrusion molding section 72 and the second mold molding section 75.

The above-described weather strip 70 has the following
10 problems: The front door weather strip needs three extrusion molding sections 71, 72 and 73, and three mold molding sections 74, 75 and 76. Therefore, those sections 71 through 76 must be formed in different manufacturing steps, and accordingly the number of manufacturing steps is considerably large; that is, the
15 manufacturing work is low in efficiency, and the manufacturing cost is large.

On the other hand, a method may be employed in which the second mold molding section 75 and the third mold molding section 76, which are relatively larger in the radius of curvature than
20 the first mold molding section 76, are eliminated, and the part corresponding to the upper section, the front side section, lower section and the rear side section of the front door is provided as one extrusion molding section. However, in this case, as was described above, the hollow sealing section of the part
25 corresponding to the corner section between the front side section

and the lower section of the front door is deformed in such a manner that the hollow sealing section collapses; that is, the predetermined sealing force cannot be obtained.

5

SUMMARY OF THE INVENTION

In view of the foregoing, an object of the invention is to provide a front door weather strip and its manufacturing method which are designed as follows: The manufacturing work is high in efficiency, and manufacturing cost is low, and substantially
10 the same sealing force is obtained at any point of the weather strip.

To achieve the forgoing object, according to one aspect of the present invention, there is provided a front door weather strip provided with a base section mounted on a periphery of a
15 front door of a vehicle, and a hollow sealing section extended from the base section. The weather strip has an annular shape as a whole, the base section and the hollow sealing section are formed all over a periphery of the weather strip. Further, the weather strip comprises a mold molding section corresponding to
20 a corner of a rear side upper section of the front door, the mold molding being formed with a mold, and an extrusion molding section being formed continuous by extrusion molding. The extrusion molding section comprises: a first part corresponding to a region of from an upper section to a front side section of the front door,
25 the first part having a seal lip; a second part corresponding to

a corner part between the upper section and the front side section of the front door; a third part corresponding to the front side section; a fourth part corresponding to a corner part between the front side section and a lower section of the front door, a height
5 of the hollow sealing section at the fourth part is larger than other parts in the weather strip; and a fifth part corresponding to the lower section and a rear side section of the front door.

A base end of the sealing section on a vehicle outside at least the lower section of the fifth part is smaller in thickness than
10 that of a part in the first part corresponding to the upper section of the front door.

In a preferred embodiment, a length of the seal lip is gradually changed so as to become zero at the second part.

In another preferred embodiment, both side walls of the
15 hollow sealing section at the fourth part are added to a same volume substantially uniformly thickness, so that a height of the hollow sealing section at the fourth part is larger than other parts in the weather strip.

According to another aspect of the present invention,
20 there is provided a method for manufacturing a front door weather strip provided with a base section mounted on a periphery of a front door of an automobile, and a hollow sealing section extended from the base section. The weather strip has an annular shape as a whole, the base section and the hollow sealing section are
25 formed all over a periphery of the weather strip. The method

comprises the steps of: (A) continuously forming one extrusion molding section by extrusion molding, comprising the steps of: forming a first part corresponding to a region of from an upper section to a front side section of the front door, the first part
5 having a seal lip integral with the hollow sealing section; forming a second part corresponding to a corner part between the upper section and the front side section of the front door, a length of the seal lip being gradually changed so as to become zero, and the hollow sealing section being changed to a substantially
10 circular shape from a shape of the hollow sealing section at the first part; forming a third part corresponding to the front side section, the hollow sealing section being changed to an elliptic shape from the substantially circular shape of the hollow sealing section at the second part; forming a fourth part corresponding
15 to a corner section between the front side section and a lower section of the front door, a height of the hollow sealing section at the second part is larger than other parts in the weather strip; and forming a fifth part corresponding to the lower section and a rear side section of the front door, wherein a base end of the
20 sealing section on a vehicle outside in at least the lower section of the fifth part is smaller in thickness than that of a part in the first part corresponding to the upper section of the front door; and (B) forming a mold molding section corresponding to a corner of a rear side upper section of the front door using a mold
25 so as to connect both ends of the extrusion molding section,

thereby manufacturing the front door weather strip.

In a preferred embodiment, the step (A) is executed using an extrusion molding machine having a die of which an opening is variable in configuration.

5 According to the present invention, the front door weather strip is annular as a whole, and its base section is attached to the periphery of the front door of the vehicle. And the hollow sealing section extended from the base section seals the gap between the front door and the vehicle body.

10 In the invention, the weather strip is made up of one extrusion molding section and one mold molding section through which both end of the extrusion molding section are connected to each other. Hence, the number of manufacturing steps is considerably small.

15 In addition, the part of the extrusion molding section which corresponds to the region of from the upper section of the front door to the front side section has the seal lip which is formed integral with the sealing section, and the length of the seal lip is gradually changed at a corner part between the upper
20 section and the front side section.

 Furthermore, in the part which corresponds to the corner section between the front side section and the lower section of the front door, the hollow sealing section is larger in height than the other parts. Therefore, even if, when the weather strip
25 is fixed to the front door, the part is bent and therefore the

sealing section collapses somewhat; that is, it is deformed, the deformation is estimated in advance. That is, when the extrusion molding section is bent, the height of the sealing section of the part thus deformed is almost equal to the height of the other part.

5 Accordingly, the sealing force will never be decreased.

In the part which corresponds to the upper section of the front door, in order to prevent the suction deformation of the door during the high speed traveling, it is necessary to obtain a predetermined lap margin and to increase the sealing force.

10 Therefore, the sealing section should have a predetermined thickness. On the other hand, if the sealing force is too high, the front door closing force is increased.

Therefore, the present invention has the above-described function and the following function: In the part which
15 corresponds to the lower section of the front door, a base end of the sealing section on a vehicle outside in at least lower section of the fifth part is smaller in thickness than that of a part in the first part corresponding to the upper section of the front door. Therefore, the front door closing force is not
20 increased so much. Hence, the above-described function is more positively obtained.

Still further, the front door weather strip which performs the function of the invention described in can be positively obtained by a method of according to the present
25 invention.

BRIEF DESCRIPTION OF THE DRAWINGS

In the accompanying drawings:

FIG. 1 is an explanatory side view showing a front door
5 weather strip, which constitutes an embodiment of the invention;

FIG. 2 is a perspective view mainly showing a mold
molding section of the weather strip;

FIG. 3 is a sectional view taken along line J-J of FIG.
1, showing the coupling of the weather strip to the front door;

10 FIG. 4 is a sectional view taken along line K-K of FIG.
1 showing the coupling of the weather strip to the front door;

FIG. 5 is a sectional view taken along line L-L of FIG.
1 showing the coupling of the weather strip to the front door;

15 FIG. 6 is a sectional view taken along line M-M of FIG.
1 showing the coupling of the weather strip to the front door;

FIG. 7 is a sectional view taken along line N-N of FIG.
1 showing the coupling of the weather strip to the front door;

FIG. 8 is an explanatory side view showing a conventional
front door weather strip;

20 FIG. 9 is a sectional view taken along line A-A in FIG.
8;

FIG. 10 is a sectional view taken along line B-B in FIG.
8; and

FIG. 11 is a sectional view taken along line C-C in FIG.
25 8.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

A front door weather strip, which constitutes an embodiment of the invention, will be described with reference to
5 FIG. 1 through FIG. 7.

As shown in FIGS. 1 and 3, the front door weather strip (hereinafter referred to as "a weather strip when applicable) 11 is mounted on the door frame 12 of the vehicle front door, and is annular as a whole. The weather strip 11 comprises: one mold
10 molding section 13 (cf. FIG. 2) which is positioned on the corner section of the rear side upper section; and one extrusion molding section 14 which is formed by extrusion molding. The mold molding section 13 is so formed as to connect both ends of the extrusion molding section 14. In the embodiment, the weather strip 11 is
15 made of EPDM (ethylene-propylene-diene terpolymer) sponge rubber.

The extrusion molding section 14 is fundamentally made up of a base section 15 which is mounted on the door frame 12, and a sealing section 17 which is extended from the base section
20 15 and has a hollow 16 (the mold molding section 13 being the same in fundamental construction). The base section 15 is secured to the door frame 12 through an adhesive double coated tape 18 or with a clip (not shown).

As shown in FIG. 3, the part of the extrusion molding
25 section 14 which corresponds to the region of from the upper

section of the door frame 12 to the front side section (on the left side of FIG. 1) is so formed that a seal lip 19 and a rear surface lip 29 are extended outwardly with respect to the sealing section 17 and are integral with each other. Hereinafter, this parts is defined as a first part for the explanation. As shown in FIG. 4, the length of the seal lip 19 is gradually decreased at a corner part between the upper section (the first part) and the front side section. Hereinafter, this corner part is defined as a second part. The sealing section 17 at the second part is substantially circular in section. That is, the sectional shape of the sealing section 17 is changed from substantial ellipse at the first part to substantial circle at the second part. Further, a contact portion with a vehicle body 20 is a side portion adjacent to the top portion of the sealing section 17 at the first part, however, it is changed to a top portion (a portion most separate from the base section) of the circular section of the sealing section 17 at the second part. In addition, as shown in FIG. 5, in the part of the extrusion molding section 14 which corresponds to the front side section (the part which corresponds to the hinge of the front door), no seal lip 19 is formed, and the rear surface lip 29 is short. Hereinafter, this part is defined as a third part. The sealing section 17 at the third part is changed in section from the second part, so the sealing section 17 at the third part is so formed that it is elliptic in section, and is extended obliquely.

As shown in FIG. 6, in the part of the extrusion molding section 14 which corresponds to the corner part between the front side section and the lower section of the door frame 12, the height of the sealing section is larger than that of the other section (the front side section and the lower section). Hereinafter, this lower corner part is defined as a fourth part. That is, with respect to the part corresponding to the aforementioned corner, during extrusion molding, both side walls of the sealing section 17 are added to the same value substantially uniformly thickness over the height T1, and therefore the sealing section 17 is higher than the other sections.

As shown in FIG. 7, in the part of the extrusion molding section 14 which corresponds to the lower section and a rear side section of the door frame 12 (Hereinafter, this portion is defined as a fifth part.), and in at least the lower section of the fifth part, its thickness is smaller the thickness of the vehicle outside base end of the sealing section 17 of the part which corresponds to the upper section of the door frame 12.

A process of manufacturing the weather strip thus constructed will be described in brief. Devices used for the manufacture of the weather strip are not shown.

First, an extrusion molding machine is used, to extrude not-vulcanized EPDM having a sectional configuration of the aforementioned extrusion molding section 14 through a die having a predetermined opening. In this case, a variable extrusion

mechanism is used to cause the extrusion molding section 14 to have the above-described various sectional configurations. That is, the configuration of the extrusion opening of the die is variable according to the sectional shape of the weather strip.

5 Thereafter, the not-vulcanized EPDM thus extruded is vulcanized with the vulcanizing machine, and then cooled.

 Under this condition, a metal mold device is used to form the mold molding section 13 in such a manner as to connect both ends of the extrusion molding section 14. Thus, the above-
10 described annular weather strip 11 has been manufactured.

 Now, the functions and effects of the embodiment will be described.

 (1) In the use of the weather strip 11, the hollow sealing section 17 extended from the base section 15 seals the gap between
15 the door frame 12 and the vehicle body 20.

 (2) The weather strip 11, the embodiment of the invention, is made up one extrusion molding section 14 and one mold molding section 13. Therefore, the number of manufacturing step is considerably small. Accordingly, the manufacturing work is high
20 in efficiency, and the manufacturing cost is very low.

 (3) In the region of from the upper section of the door frame 12 to the front side section (first part) has the sealing lip 19. Then, the seal lip 19 of the second part of the extrusion molding section 14 which corresponds to the upper corner part
25 between the upper section of the door frame 12 and the front side

section is so formed that its length is gradually decreased.

Therefore, sealing force of the seal lip 19 may be equalized at the upper section of the door frame.

(4) Further, the third part of the extrusion molding
5 section 14 corresponds to the front side section of the door frame 12. The sealing lip 19 is not formed at the third part. Therefore, it is possible to narrow the gap between the front side section and the vehicle body as compared with the gap at the first part.

And it is possible to form a shape of the sealing section same
10 as that of the conventional-type weather strip while the weather strip is from by one continuous extrusion molding.

(5) Furthermore, the fourth part of the extrusion molding
section 14 which corresponds to the lower corner part between the front side section of the door frame 12 and the lower section is
15 so formed that the height of the sealing section 17 is higher than the other parts (FIG. 6). Therefore, even if, when the weather strip is mounted on the door frame 12, the fourth part is bent and the sealing section 17 collapses somewhat; that is, it is deformed, the deformation is estimated in advance. That is, when
20 the extrusion molding section 14 is bent, the height thereof is almost equal to the heights of the other parts. Accordingly, the sealing force will never be decreased.

(6) Especially, the fourth part corresponding to the lower corner part is as follows: in the extrusion molding work,
25 both side walls of the sealing section 17 are added the same value

substantially uniformly thickness, so that the height of the sealing section 17 is higher than the other sections. Hence, when the extrusion molding section is bent, the sealing section 17 thereof will collapse; that is, the right and left parts thereof are uniformly deformed. Accordingly, the above-described functions and effects are more positive.

(7) In addition, in the region corresponding to the upper section of the door frame 12, in order to deal with the suction deformation of the front door during the high speed traveling, it is necessary to obtain a predetermined lap margin there by to increase the sealing force. Therefore, the sealing section 17 should have a predetermined thickness. On the other hand, the part corresponding at least to the lower section of the door frame 12, is less in the above-described requirement than the part corresponding to the upper section. On the other hand, if the whole sealing force is too great, the front door closing force is increased.

(8) In view of the foregoing, the thickness of the fifth part which corresponds at least to the lower section of the door frame 12 is smaller than the thickness of the vehicle outside base end part of the sealing section 17 of the part corresponding to the upper section, and therefore, the front door closing force can be decreased. As a result, at the time of closing the door, the operability is improved.

(9) And, because of this fact, the amount of material used

can be decreased as a whole. As a result, the amount of EPDM used can be decreased, and the manufacturing cost can be decreased.

(10) In the embodiment, in addition to the above-described functions and effects of (3) through (6) and (8), the following sealing effect is obtained: that is, at any section
5 sealing effect is substantially equal.

(11) In the method of manufacturing the weather strip 11 according to the invention, the weather strip 11 having the above-described functions and effects can be positively obtained.

10 The invention is not limited to the above-described embodiment; that is, it will be obvious to those skilled in the art that various changes and modifications may be made therein without departing from the spirit of the invention as follows:

(a) In the above-described embodiment, the weather strip
15 11 is made of one kind of rubber (EPDM sponge rubber). The material may be suitably replaced other materials. For instance, the mold molding section 13 may be formed with EPDM solid rubber or thermoplastic elastomer.

(b) In the above-described embodiment, in the part of the
20 extrusion molding section 14 which corresponds to the upper corner part between the upper section of the door frame 12 and the front side section, the length of the seal lip 19 is gradually decreased.

However, in all the regions of the upper section, if the sealing force of the seal lip 19 will be equal, the seal lip 19 may be
25 gradually changed in length.

As was described above, with the front door weather strip according to the present invention, the manufacturing work is improved in efficiency, and the manufacturing cost is decreased.

And any parts of the weather strip are substantially equal in
5 sealing performance.

Furthermore, any parts of the weather strip are more positively equal in sealing performance.

In addition, according to the front door weather strip manufacturing method according to the present invention, the
10 weather strip having the above-described effects can be positively obtained.

WHAT IS CLAIMED IS:

1. A front door weather strip provided with a base section mounted on a periphery of a front door of a vehicle, and a hollow sealing section extended from the base section, the weather strip having an annular shape as a whole, the base section and the hollow sealing section being formed all over a periphery of the weather strip, said weather strip comprising:

a mold molding section corresponding to a corner of a rear side upper section of the front door, said mold molding being formed with a mold; and

an extrusion molding section being formed continuous by extrusion molding, said extrusion molding section comprising:

a first part corresponding to a region of from an upper section to a front side section of the front door, said first part having a seal lip;

a second part corresponding to a corner part between the upper section and the front side section of the front door;

a third part corresponding to the front side section;

a fourth part corresponding to a corner part between the front side section and a lower section of the front door, a height of said hollow sealing section at said fourth part is larger than other parts in said weather strip; and

a fifth part corresponding to the lower section

and a rear side section of the front door,

wherein a base end of said sealing section on a vehicle outside in at least the lower section of said fifth part is smaller in thickness than that of a part in said first part corresponding
5 to the upper section of the front door.

2. A front door weather strip according to claim 1, wherein, a length of said seal lip is gradually changed so as to become zero at said second part.

10

3. A front door weather strip according to claim 1, wherein, both side walls of said hollow sealing section at said fourth part are added to a same volume substantially uniformly thickness, so that a height of said hollow sealing section at said
15 fourth part is larger than other parts in said weather strip.

4. A method for manufacturing a front door weather strip provided with a base section mounted on a periphery of a front door of an automobile, and a hollow sealing section extended
20 from the base section, the weather strip having an annular shape as a whole, the base section and the hollow sealing section being formed all over a periphery of the weather strip, said method comprising the steps of:

(A) continuously forming one extrusion molding section
25 by extrusion molding, comprising the steps of:

forming a first part corresponding to a region of from an upper section to a front side section of the front door, said first part having a seal lip integral with the hollow sealing section;

5 forming a second part corresponding to a corner part between the upper section and the front side section of the front door, a length of said seal lip being gradually changed so as to become zero, and the hollow sealing section being changed to a substantially circular shape from a shape of the hollow
10 sealing section at the first part;

 forming a third part corresponding to the front side section, the hollow sealing section being changed to an elliptic shape from the substantially circular shape of the hollow sealing section at the second part;

15 forming a fourth part corresponding to a corner section between the front side section and a lower section of the front door, a height of said hollow sealing section at said second part is larger than other parts in said weather strip; and

 forming a fifth part corresponding to the lower
20 section and a rear side section of the front door, wherein a base end of said sealing section on a vehicle outside in at least said lower section of said fifth part is smaller in thickness than that of a part in said first part corresponding to the upper section of the front door; and

25 (B) forming a mold molding section corresponding to a

corner of a rear side upper section of the front door using a mold so as to connect both ends of the extrusion molding section, thereby manufacturing the front door weather strip.

- 5 5. A method for manufacturing a front door weather strip according to claim 4, wherein said step (A) is executed using an extrusion molding machine having a die of which an opening is variable in configuration.



Application No: GB 9902987.8
Claims searched: 1-5

Examiner: D.J. Pisani
Date of search: 16 March 1999

Patents Act 1977
Search Report under Section 17

Databases searched:

UK Patent Office collections, including GB, EP, WO & US patent specifications, in:
UK CI (Ed.Q): E1J JGN, JM
Int CI (Ed.6): B60J 10/00, 10/08
Other: Online: World Patents Index, EPODOC, Patent Abstracts of Japan databases

Documents considered to be relevant:

Category	Identity of document and relevant passage	Relevant to claims
A	US 5240664 TOYODA GOSEI CO., LTD.	
A	US 4979333 TOYODA GOSEI CO., LTD.	
A	US 4964620 TOYODA GOSEI CO., LTD.	
A	US 4960375 KINGUAWA RUBBER INDUSTRIAL CO., LTD.	

X	Document indicating lack of novelty or inventive step	A	Document indicating technological background and/or state of the art.
Y	Document indicating lack of inventive step if combined with one or more other documents of same category.	P	Document published on or after the declared priority date but before the filing date of this invention.
&	Member of the same patent family	E	Patent document published on or after, but with priority date earlier than, the filing date of this application.